

Date: Thursday, 11/23/2006 11:56:21 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 204 SKIDTUBE "I" BEAM		
Job Number	: 29675		Part Number	: D2597		
Estimate Number	: 10996		Drawing Number	: D2597 REV D		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 11/23/2006 S.O. No. : N/A		Drawing Revision	: D		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 12/5/2006		
Previous Run	: 28802		Qty:	4	Um:	Each
Written By	:					
Checked & Approved By	:					
Comment	: Est: D 98.10.15 Eliminated DEO, Changed Dwg Revision KS					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D25003100	Ex'tn - 'I' Beam Web 4"
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Extrusion "I" Beam Web 4" Pick; Qty Part Number Description Batch 1 D2500-3-100 Extrusion <u>1325751</u> <u>m.a 06/11/30</u>		
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1 <u>m.a 06/11/30</u> <u>④</u>
Comment: LANDING GEAR RESOURCE 1 Cut D2500-3 to length: 84.25" Use Jig DT8094 to drill pilot holes. Open to 0.625 diameter using a uni-bit.		
3.0	QC5	INSPECT WORK TO CURRENT STEP <u>Ph 06-11-30</u> <u>④</u>
Comment: INSPECT WORK TO CURRENT STEP		
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 <u>m.a 06/11/30</u> <u>④</u>
Comment: HAND FINISHING RESOURCE #1 Acid Etch and Alodine per QSI 005 4.1		
5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION <u>Ph 06-11-30</u> <u>④</u>
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

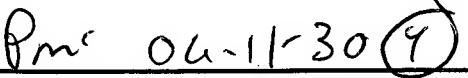
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

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Job Number: 29675		Part Number: D2597
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	PACKAGING 1 	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>LG</u> 		
7.0	QC21 	FINAL INSPECTION/W/O RELEASE  
Comment: FINAL INSPECTION/W/O RELEASE  		
Job Completion		

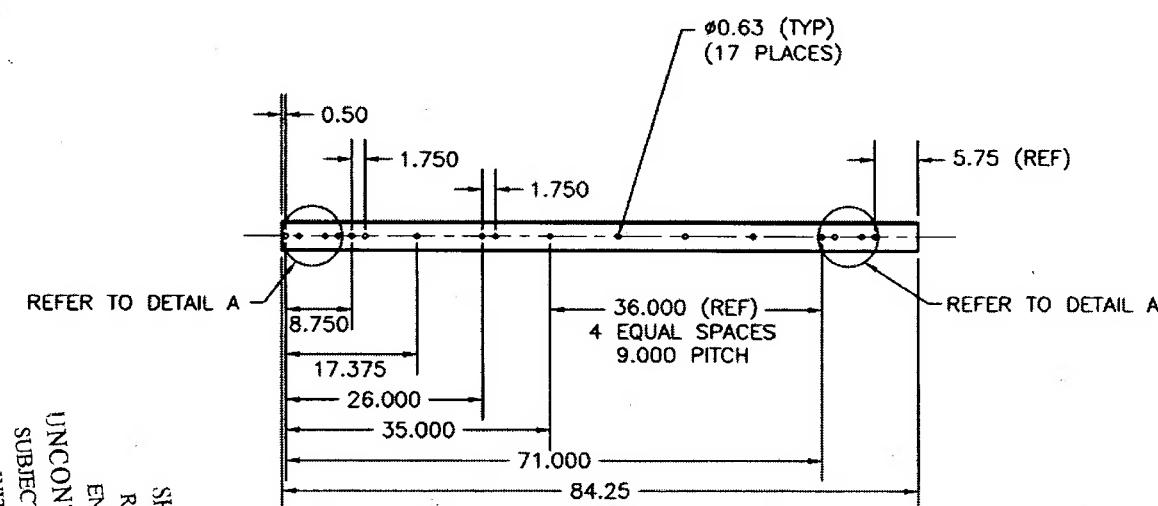
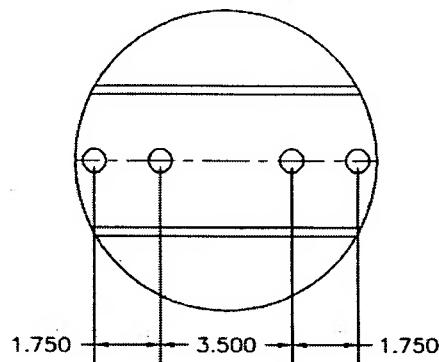
W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DETAIL A
SCALE 5:24



MANUFACTURED FROM D2500-3 EXTRUSION
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29675

RELEASED
48.9.17
SS

DESIGN	DRAWN BY	DART AEROSPACE LTD	
		HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. D
<i>PF</i>	<i>PF</i>	D2597	SHEET 1 OF 1
DATE		TITLE	SCALE
98.09.14		204 WEB	1:24